

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-000486**Date Inspected:** 03-Sep-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	CAWI/QC Zhu Zhong Hai,	CWI Present:	Yes	No
Inspected CWI report:	Yes No N/A	Rod Oven in Use:	Yes No	N/A
Electrode to specification:	Yes No N/A	Weld Procedures Followed:	Yes No	N/A
Qualified Welders:	Yes No N/A	Verified Joint Fit-up:	Yes No	N/A
Approved Drawings:	Yes No N/A	Approved WPS:	Yes No	N/A
		Delayed / Cancelled:	Yes No	N/A
Bridge No:	34-0006	Component:	77 Mock-Up/114-B	

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the random observations related to the following;

Item-1 Skin Plate-D, Stiffener Plate 3 (both sides). Root weld had previously been ground and made ready for Magnetic Particle (MT) testing. The MT testing was performed by Zhou Dong Jun #12179 and Cai Xin Xin and was witnessed by Caltrans QA Inspector. It was observed that one of the men was performing the test in one direction only. When this was brought to his attention he started performing the MT test in two directions, one 90 degrees from the other, and was found to be MT/okay. The Caltrans QA Inspector did MT approximately 40% of the root welding on each side of the stiffener plate and was found to be in compliance with the project specifications. The plate will be preheated for the welding of the filler passes. The QA present was Fu Yuhong & Li Xiu Yong.

Item-2 Top Plate 114-B. Tack welding imperfections had been ground off and was ready for MT testing. Caltrans QA Inspector did witness Cai Xin Xin performing the magnetic particle testing, MT okay. The Caltrans QA Inspector did MT approximately 40% of the tack welding and found them to be in compliance with project specifications. Root pass has now been completed and Cai Xin Xin was observed performing the MT test and was MT/okay. Caltrans QA Inspector did MT approximately 40% of the root weld and was found to be acceptable. The CWI/QC present was Xu Bing & CWI/QC Hou Jing Yao & Xu Liang Zhang.

Item-3 Skin Plate-E Stiffener Plate 1. The root weld had been ground down and a visual observation disclosed no discrepancies. It was suggested that prior to the preheat that the root areas be cleaned with a power wire brush. No one could locate a power wire brush wheel and a small brass brush for a die grinder was utilized. The ZPMC QA was Shen Xue Jun & the QC Chen Tan the CWI/QC was Xu Bing & CWI (BV) Xu Liang Zhang.

Item-4 Top Plate 114-D Lifting devices being welded in position.

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Smith,David	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
